Work Orde				*949	308*				X	fc.	P	Page 1
Revision ID:	D3933-2 Aft Cabin Wal	Il Protector, RH		Accept	*N90	೧ ೧4೧	100)*		Start Stop	*N *N	S1*
Start Date: Required Date: Reference:	12/24/2012 1/3/2013	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Iter Custome						IV	. 1/
Approvals:	Process Pla	n: MF	Date: \2 -\2-2'	Tooling: SPC (Y/N):		Date:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3933	A											
*100				0.00				B				B13×1-3
Waterjet FLOW CNC Waterje	et	Memo 1-Cut as per Dwg Rev:_ Prog Rev:_ 2- Deburr if	4	0.00				9-1				
110		QC2- Inspect parts off m	nachine FAI/FAIB	0.00				,				
110 QC Quality Control		Мето		0.00				(3)				1313-1-3

W. 45. 18. 3

	DQA: Date:													
NCR:	'es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE	QA Closed:	Date	<u> </u>	
		·				DISPOSITION				AGAINST DE				
Work Orde	er: -	- · · - · · ·					-, i							
Part N	-					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			4	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
TTCT T			 			Work Order opudie	_		carge rap	composite	_	Supplier		
Root					Descri	ption of work order update		nitial	Acti	on	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector	
oc/Data quip/Tooling										- 11 - 10 - 11		-	*	
perator														
1aterial														
etup														
ther														
rocess	_													
upplier														
raining	_													
napproved								<u> </u>						
							FAUL	T CATE	GORY					
Landii	$\overline{}$					General		1			- .	г	-	
	_	Bending				Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced	
	괵	Centre No	ot Concer	ntric to	o/s _	BOM/Route	_	Hardwa		<u> </u>	Over/Under	-	Temperature/Cure	
	-	Cracks				Broken/Damaged	\vdash	-1	on Incomplete	_	Part Incorred	- t	Weld	
		Crushed/0	Crimped.	•	<u> </u>	Burrs	<u> </u>	-1	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
Cuffs Contamination					_	Mainte		<u> </u>	Part Moved					
Heat Treat Countersink						_	Mislabeled			Positioned V				
Inspection Strip in Tube Cut Too Short						-	Misread			Power Loss/Surge Other				
	ᅴ	Ripples in			<u> </u>	Drill Holes	-	Offset						
Torque Waves in Extrusion Drawing								Out of 0	Out of Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Monday, Decem					*	949	N8 *								Page 2	
Revision ID:	D3933-2 Aft Cabin Wa	ll Protector, RH			Accept		*N9	nn	040	100)*	Setup	Start Stop	*N:	S1*	
	12/24/2012	Start Qty: 3.00 Req'd Qty: 3.00		*3* *3*			Cust I Custo		D:					^N	S2*	
Approvals:		in:							ite:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 120 *120 CC QC Quality Control		Operation Description QC8- Inspect parts - sec	cond check		0.00	Hours	Tool	ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
130 *130* Packaging Packaging		Identify as per dwg & S Memo	tock Location:_		0.00	gpp 94	900			,	(3))			13/0		0
140 *14 *14 CC Quality Control		QC21- Final Inspection Memo	- Work Order Ro	elease	0.00						4.4	/	5	13-	01-04 DH	,

Jacobs City

			DQA:	Date:	:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

											QA Closed:	Date:	
Work Orde	er:				·	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	. No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Sto	Engineering Quality Other	
Root					Descri	ption of work order update	Ir	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
			<u> </u>			F	AUL	T CATE	GORY		1	L	
Landi	ng G	Gear				General							
		Bending Centre No Cracks Crushed/o Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped at n Strip in n Bend Vaves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete tions Incomplete/ enance eled	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	П	Wave/Tw	ist in Tuk	ne .		Folio	П	Outside	Dimensions				•

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Monday, December 24, 2012 11:10:23 AM

Page 1

Work Order ID:

94908

Parent Item:

D3933-2

Parent Item Name:

Aft Cabin Wall Protector, RH

Start Date: 12/24/2012

Required Date: 1/3/2013

Start Qty: 3.00

Required Qty: 3.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	HEET	Purchased	No		· · · · · · · · · · · · · · · · · · ·	100	sf	555.0613	7.01	21.03	B13-	-1-3	
				Location		Loc Qty	Lo	c Code					
				MAT019		555.0613					محسا		
				121	803	555.0613			121	803)	

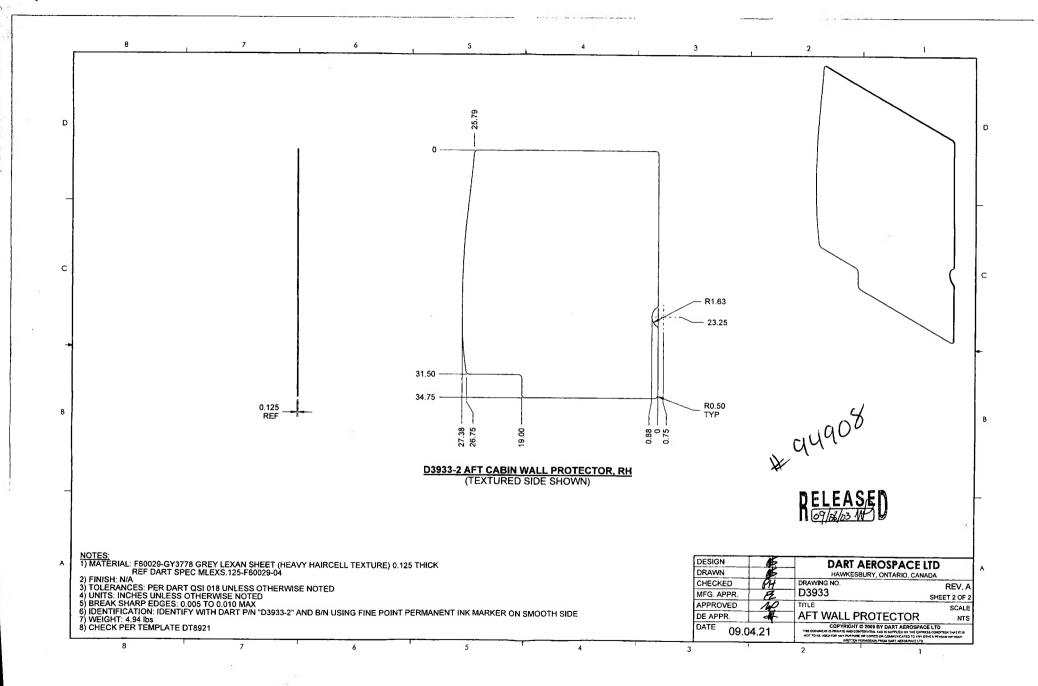
							1					DQA:	Date	:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	ANCE / UPI	DATE	•			
									-			QA Closed:	Date	:	
Work Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
Part I	No.						Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	=	Water Jet d. Eng. Coor. re/Packaging Supplier	E	ngineering Quality Other
Root					Des	criț	otion of work order update	1	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification		QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier raining															÷
								AUL	T CATE	GORY					
Landi	ng (1					General		1			٦	Г	_	
		Bending Centre No Cracks Crushed/0			O/S		Bend BOM/Route Broken/Damaged Burrs		1 '	re on Incomplete ions Incomplete/I	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Ter	essure/Forced mperature/Cure eld ong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved			
		Heat Trea	t				Countersink		Mislabe	led		Positioned V		_	
	<u> </u>	Inspection		Tube			Cut Too Short		Misread	l		Power Loss/	Surge	Otl	ner
	L	Ripples in	Bend				Drill Holes		Offset						
	L	Torque W	aves in E	xtrusio	n		Drawing		Out of (Calibration					
		Turning S	equence				Finish		Out of 9	Sequence			C		·

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



DQA:	Date:	
		 -

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No WORK ORDER NON-CONFO

<u> </u>	·							•		QA Closed:	Date	
Work Order	··				DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part No					Rework Scrap		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet	Engineering Quality
NCR No	o			<u> </u>	Use-as-is Work Order Update	1		Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Ir	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
quip/Tooling Operator Material etup Other rocess upplier fraining								,				
Inapproved						A	CATE	CORV				
Landin	- Goor				General	AUL	CATE	JUNT				· · ·
Landin	Bending Centre No Cracks			o/s	Bend BOM/Route Broken/Damaged			on Incomplete		Ovalized Over/Under Part Incorre	ct	Pressure/Forced Temperature/Cure Weld
-	Crushed/ Cuffs Heat Trea	·		-	Burrs Contamination Countersink		Instruct Mainte Mislabe		Unclear	Part Lost/Mi Part Moved Positioned V		Wrong Stock Pulled
Ī	Inspectio	n Strip in	Tube	-	Cut Too Short	П	Misread	i		Power Loss/		Other
	Ripples in	Bend			Drill Holes		Offset		<u> </u>			
	Torque W	/aves in E	xtrusio	n [Drawing		Out of 0	Calibration				
	Turning S	equence			Finish		Out of S	Sequence				
	Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	94908
Description: Aft Cabin Wall Protector, RH	Part Number:	D3933-2
Inspection Dwg: D3933 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	. 88	_		7 BJ1	
19.00	+/-0.030	19,00			7	
26.75	+/-0.030	26.75	U		7	
27.38	+/-0.030	92.38	J		7	
34.75	+/-0.030	34.75	ı		7	. •
31.50	+/-0.030	31,50	U		7	
25.79	+/-0.030	75.79)		÷ I	,
0.125	+/-0.010	199	Ĺ		U BOZ	
23.25	+/-0.030	23.26	^		Т	·
			ÛÁS			

Measured by:	Audited by:	Prototype Approval:	N/A
Date: (3-1-3	Date: パル3	Date:	N/A

Ĺ	Rev	Date	Change	Revised by		v	Approved		
	Α	09.06.22	New Issue	KJ	4	Ð		1	
				1		7-) —		